

shu

Date: Tuesday, 19/08/2008 4:06:24 PM  
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER TUBE
Job Number	: 41485		
Estimate Number	: 13498		
P.O. Number	:	Part Number	: PB6743001205
This Issue	: 19/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: B6743001 P.16
First Issue	: / /	Project Number	: N/A
Previous Run	: 40776	Drawing Revision	: B1
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 18/09/2008
Checked & Approved By	: <u>JUD 08.8.20</u>	Qty:	12 Um: Each
Comment	: Est Rev:A 08-07-24 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1750W065	6061T6 RDTUBE 1.750 X 0.65W
	Comment: Qty.: 3.7958 f(s)/Unit Total: 45.5490 f(s) 6061T6 RDTUBE 1.750 X 0.65W batch: <u>m109184</u>	
2.0	BAND SAW	BAND SAW
	Comment: SMALL & MEDIUM FAB RESOURCE 1  1- cut to length as per dwg 2-cut a 27 degree angle on one end of tube as per dwg 2- deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE  1- drill holes and mill slot as per dwg PB67-43001 2- deburr	
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
5.0	PB6743001199	Outer Tube End Cap
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Outer Tube End Cap batch: <u>340039</u>	

72A 710 meter P10: 7252 0204/106 (12)  
2B weld + inspect attached C+C

Op 08-10/14  
R/S/K (12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld end cap as per dwg PB67-43001  
2-grind end cap flush

*Cpl 08-10-14*

*(x4)*

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*S 08/10/14*

*(x4)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/10/14*

*(x4)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *55513*

*-2*

*JS 08/10/16*

*(x4)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/10/17*

Job Completion



*MF 08-10-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

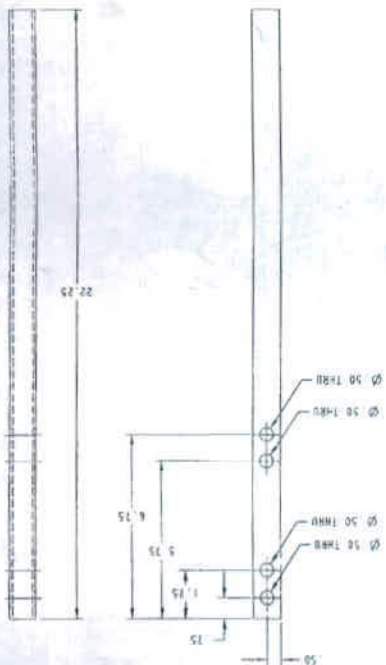
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ORIGINAL

PREMIER AVIATION, INC.  
1000 Industrial Parkway, Grand Prairie, Texas 75050  
REV. 10/78  
DWG. NO. 667-43001  
SCALE: 1/8" = 1'-0"

① -207 SQUARE TUBE  
MATE: 1.00 SQ X 1.25 WALL, 6061-T6  
SCALE: 0.500



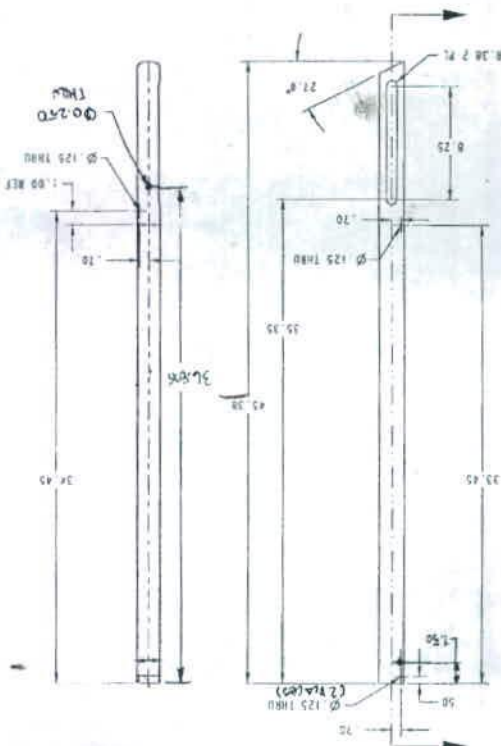
RELEASED  
10/4/78

⑤ -201 SQUARE TUBE  
MATE: 1.00 SQ X .065 WALL, 6061-T6  
SCALE: 0.500

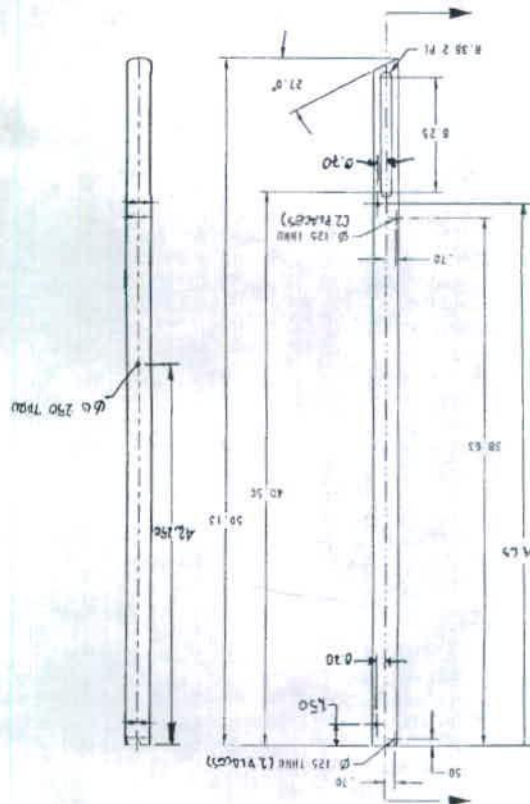


#21485

① -205 OUTER TUBE  
MATE: 1.75 SQ X .055 WALL, 6061-T6  
SCALE: 0.250



① -197 OUTER TUBE  
MATE: 1.75 SQ X .055 WALL, 6061-T6  
SCALE: 0.250







## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
12	B67-043001 197	Outer Tube B41483	7252
12	B67-043001 205	Outer Tube B41485	7252

MATERIAL supplied by DART

08/01/02

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, October 1, 2008

